



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-041
Job Sheet 173586



Part No: D3121-041

Job Qty: 1 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 3/7/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/7/18	0.00	0.00	Start Up Machining-		h.a 18-03-07
100	Bandsaw <i>Manual not</i>	1 pcs		3/7/18	0.00	0.01	Bandsaw1		h.a 18-03-07
120	QC	1 pcs		3/7/18	0.00	0.00	QC2 Machining-1		h.a 18-03-07
130	QC	1 pcs		3/7/18	0.00	0.00	QC8 Machining-1		2mm L 8/03/07
160	Packaging	1 pcs		3/7/18	0.00	0.00	Packaging3-1	CA002	8102 9 0 8VW
170	QC21-SA	1 Ea		3/7/18	0.00	0.00	QC21		3.39

Part Op 100 - Cut blanks 11.000" x 2.000" x 3.250" long
Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
160 - Location: CA2
170 - QC21- Final Inspection - Work Order Release

*pull from stock 1x D3121-141
cut to make D3121-041*

DAS
21 MAR 07 2018
9:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3121-141	1	2	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawthorn, ON K6A 1K7
CANADA
TEL.: 1 813 832-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S047877

Part: D3121-041

Job No: 173586

Serial No/Batch: S047877

Revision:

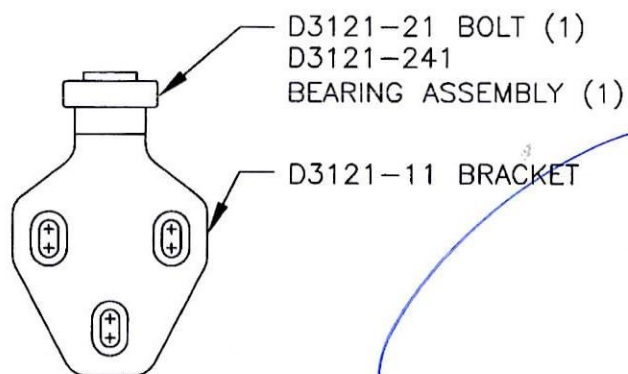
Inspector:

Date: 03/05/18

DART

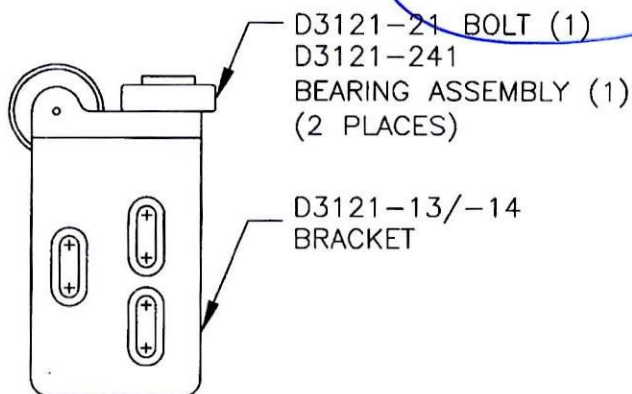
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07

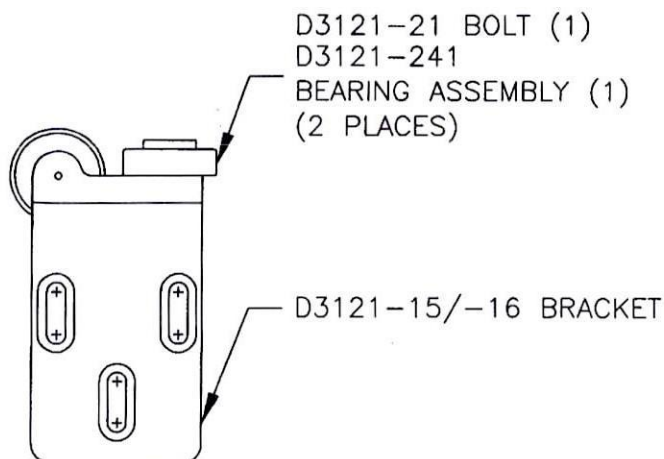


D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)

-141 out



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



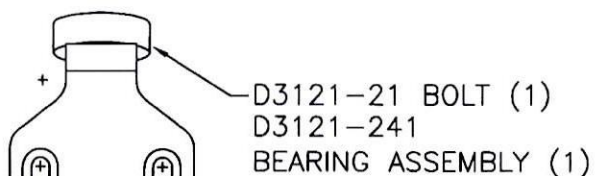
**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

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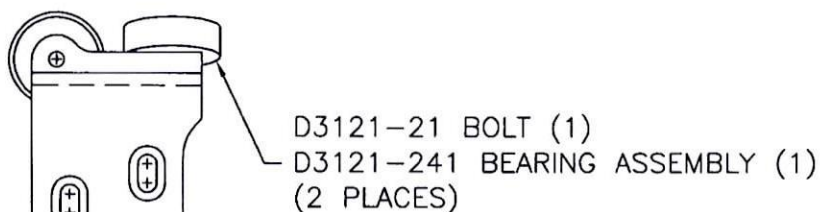
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07 

D3121-111 BRACKET



D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)

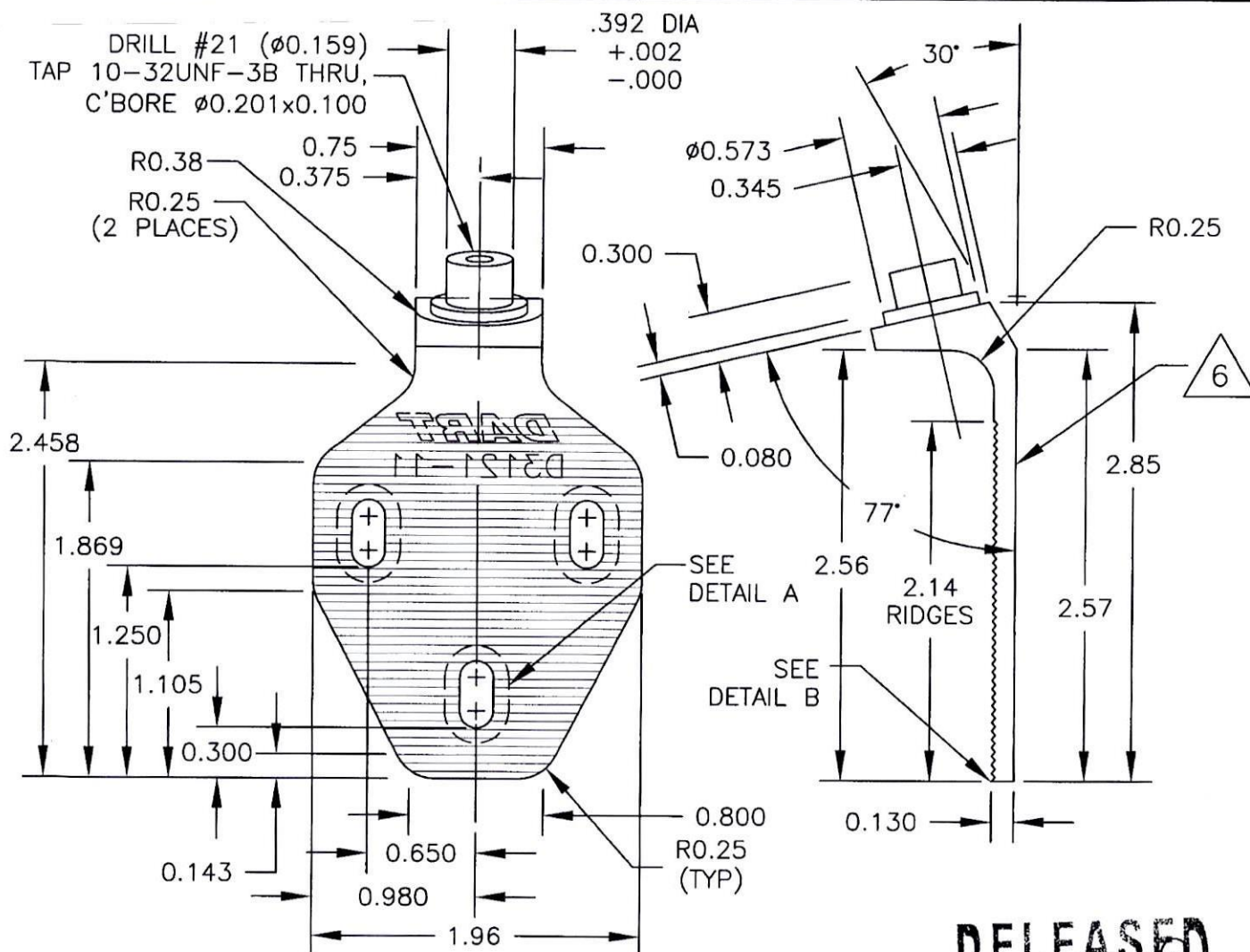
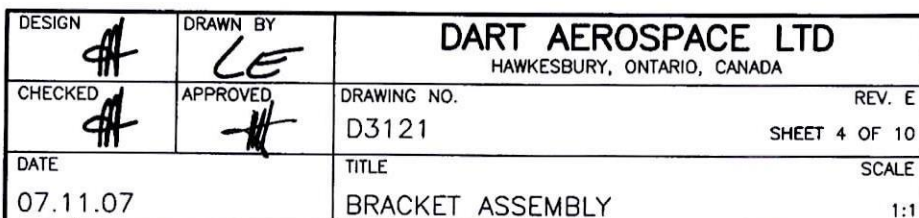


D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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RELEASED
07-11-07 *W*

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DART AEROSPACE LTD		Work Order:	173586
Description: Bracket		Part Number:	D3121-11
Inspection Dwg: D3121 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	Ø0.393	✓		Mic	GA-03
Ø0.201 x 0.100	+/-0.010	Ø0.200	✓		Vern	GA-13
0.75	+/-0.030	0.750	✓		"	"
0.375	+/-0.010	0.375	✓		"	"
1.250	+/-0.010	1.248	✓		H-6	31006
0.300	+/-0.010	0.298	✓		"	"
1.96	+/-0.030	1.966	✓		Vern	GA-13
Ø0.573	+/-0.010	Ø0.574	✓		"	"
0.345	+/-0.010	0.345	✓		"	"
0.300	+/-0.010	0.299	✓		"	"
0.080	+/-0.010	0.081	✓		"	"
2.56	+/-0.030	2.566	✓		H-6	31006
2.14	+/-0.030	2.130	✓		Vern	GA-13
0.130	+/-0.010	0.131	✓		Mic	GA-03
2.57	+/-0.030	2.572	✓		Vern	GA-B
2.85	+/-0.030	2.860	✓		"	"
0.381	+/-0.010	0.382	✓		"	"
0.400	+/-0.010	0.398	✓		"	"
0.201	+/-0.010	0.201	✓		"	"
0.580	+/-0.010	0.582	✓		"	"
0.032	+0.000/-0.010	0.029	✓		D-6	GA-08

Measured by: <u>h.e</u>	Audited by: <u>mmk</u>	Prototype Approval:	N/A
Date: <u>18-03-07</u>	Date: <u>18/03/07</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.01	New Issue P/O D3121-041	KJ/EC/DD	
B	08.06.02	Tolerance revised for Ø0.573	KJ/DD	